

housing 110, brace 210 and spring 410) using a cold work process provides a near perfect net component that only requires minimal machining or touching up to satisfy the tight tolerance requirements of the component.

[0051] The following flow chart will serve to illustrate a process involved in some embodiments of this invention. FIG. 7 is a flow chart of an illustrative process for assembling a bezel with a housing to form the case of a portable electronic device in accordance with an embodiment of the present invention. Process 700 begins at step 702. At step 704, a brace is affixed to the inner surface of the housing of the case. The brace may be affixed using any suitable approach including, for example, an adhesive or a fastener. The brace may include a rib for securing a spring, and a slot for receiving the bezel. At step 706, a spring is inserted and secured in the brace. The spring may be configured to fit in a rib of the brace such that the spring remains positioned within the rib. In some embodiments, the order of steps 704 and 706 may be reversed.

[0052] At step 708, the bezel is placed over the brace, and the walls of the attachment portion of the bezel are aligned over the slot of the brace. At step 710, the bezel is pressed into the brace such that the wall is inserted in the slot of the brace, and such that at least one engaging member of the bezel engages an aperture in the spring. The case is assembled once the spring simultaneously engages the brace and the bezel. Process 700 then ends at step 712.

[0053] In another embodiment, the assembly process may be performed as follows. The spring may be assembled to the brace. The spring/brace combination is assembled to bezel, which may cause the spring to be captured between the bezel and the brace.

[0054] The above described embodiments of the present invention are presented for purposes of illustration and not of limitation, and the present invention is limited only by the claims which follow.

1-20. (canceled)

21. A mobile telephone, comprising:

a lower housing structure defining a rear exterior surface of the mobile telephone;

a cover sheet defining a portion of a front exterior surface of the mobile telephone opposite the rear exterior surface;

a display positioned beneath a substantial entirety of the front exterior surface of the mobile telephone; and

an upper housing structure coupled to the lower housing structure, wherein:

the cover sheet, the lower housing structure, and the upper housing structure cooperate to surround the display; and

the lower housing structure and the upper housing structure cooperate to define a continuous, curved external surface of the mobile telephone.

22. The mobile telephone of claim 21, wherein:

the lower housing structure and the upper housing structure cooperate to form an external sidewall of the mobile telephone;

the external sidewall of the mobile telephone defines the continuous, curved external surface; and

the continuous, curved external surface extends from the front exterior surface to the rear exterior surface.

23. The mobile telephone of claim 21, wherein:

the front exterior surface is substantially planar; and the cover sheet defines substantially all of the front exterior surface of the mobile telephone.

24. The mobile telephone of claim 21, wherein the upper housing structure is formed from metal.

25. The mobile telephone of claim 21, wherein the upper housing structure forms a uniform border around a perimeter of the cover sheet.

26. The mobile telephone of claim 21, further comprising an engaging member extending from at least one of the lower housing structure or the upper housing structure and configured to couple the lower housing structure to the upper housing structure.

27. The mobile telephone of claim 26, wherein:

the engaging member extends from the lower housing structure;

the upper housing structure comprises a slot; and

the engaging member is configured to be placed in the slot to couple the upper housing structure to the lower housing structure.

28. A mobile telephone, comprising:

an upper housing structure defining a first curved portion of an external sidewall of the mobile telephone;

a lower housing structure coupled to the upper housing structure and defining a second curved portion of the external sidewall of the mobile telephone;

a cover sheet coupled to the upper housing structure and defining a substantial entirety of a front surface of the mobile telephone, wherein:

the first curved portion of the external sidewall and the second curved portion of the external sidewall cooperate to define a continuous curvature of the external sidewall.

29. The mobile telephone of claim 28, wherein:

the lower housing structure defines a rear surface of the mobile telephone; and

the continuous curvature of the external sidewall extends from the front surface to the rear surface.

30. The mobile telephone of claim 28, wherein the cover sheet is positioned over a display positioned within the enclosure.

31. The mobile telephone of claim 30, wherein the display screen is positioned beneath a substantial entirety of the cover sheet.

32. The mobile telephone of claim 28, wherein the upper housing structure forms a uniform border around a perimeter of the cover sheet.

33. The mobile telephone of claim 28, wherein the upper housing structure is formed from metal.

34. A housing for a mobile telephone, comprising:

a cover sheet defining a planar front surface of the mobile telephone;

a lower housing structure defining a planar rear surface of the mobile telephone; and

a continuously curved external sidewall defining a curvature that extends between the planar front surface and the planar rear surface, wherein:

the continuously curved external sidewall is formed by a curved portion of an upper housing structure and a curved portion of the lower housing structure.

35. The housing of claim 34, wherein the upper housing structure forms a uniform border around a perimeter of the cover sheet.